

Date: Monday, 02/02/2009 11:50:21 AM
 User: Julie Dawson

Process Sheet

| | |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STEP HI LONG |
| Job Number : 45399 | |
| Estimate Number : 12897 | |
| P.O. Number : | Part Number : D32721 |
| This Issue : 02/02/2009 S.O. No. : | Drawing Number : D3272 REV B |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : LARGE FAB ASSY | Drawing Revision : B |
| Previous Run : 44571 | Material : |
| Written By : | Due Date : 15/02/2009 Qty: 10 Um: Each |
| Checked & Approved By : <u>JLD 09.02.09</u> | |
| Comment : Est Rev:A New Issue 07-06-09 JLM | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------|----------------|
| 1.0 | D2622120C | Step Extrusion |
|-----|-----------|----------------|



✓ **Comment:** Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2622-120 Extrusion B44064

SAD 09-02-09 (10)

| | | |
|-----|-------------|------------------------------|
| 2.0 | LARGE FAB 1 | LARGE FABRICATION RESOURCE 1 |
|-----|-------------|------------------------------|

**Comment:** LARGE FABRICATION RESOURCE 1

1-Cut D2622-120 extrusion to 116.25" long as per Dwg D3272 using cutting table setup DT 8185-2A

2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets.

3-Deburr

SAD 09-02-09 (10)

| | | |
|-----|-----|------------------------------|
| 3.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

SAD 09-02-09 (10)

| | | |
|-----|-------------|-----------------------|
| 4.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|

**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 09-02-09 (10)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 02/02/2009 11:50:21 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP HI LONG

Job Number: 45399

Part Number: D32721

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-09

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | |
|----------------------|----------------------|--|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>B</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>H</i> | DRAWING NO. D3272 | REV. B SHEET 1 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE NTS |
| A | 04.03.01 | NEW ISSUE | |
| B | 07.05.18 | D3272-1 WAS D2622-120 | |

RELEASED07.06.04 *H*

| QTY -041 | QTY -042 | PART NUMBER | DESCRIPTION |
|-------------|-------------|--------------|-------------------------------|
| X | | D3272-041 | STEP ASSEMBLY, HIGH LONG (LH) |
| | X | D3272-042 | STEP ASSEMBLY, HIGH LONG (RH) |
| | | | |
| 1 | 1 | D3065-041 | LEG ASSEMBLY |
| 2 | 2 | D3066-1 | SPACER |
| 2 | 2 | D3067-1 | END PLATE |
| 2 | 2 | D3219-1 | SUPPORT |
| 1 | 1 | D3272-1 | STEP |
| | | | |
| 16 | 16 | MS20600AD4W4 | RIVET |
| | | | |

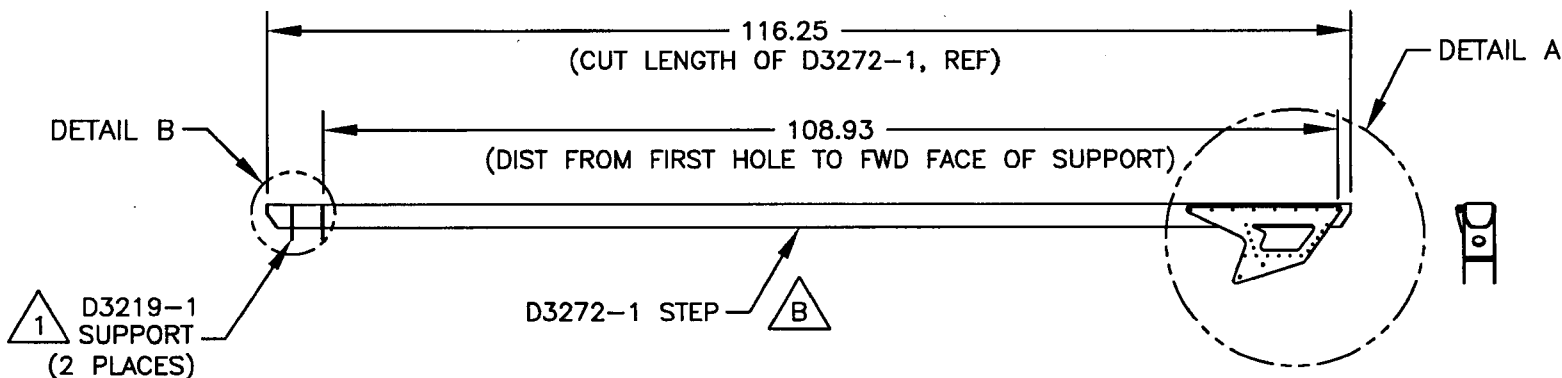
GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

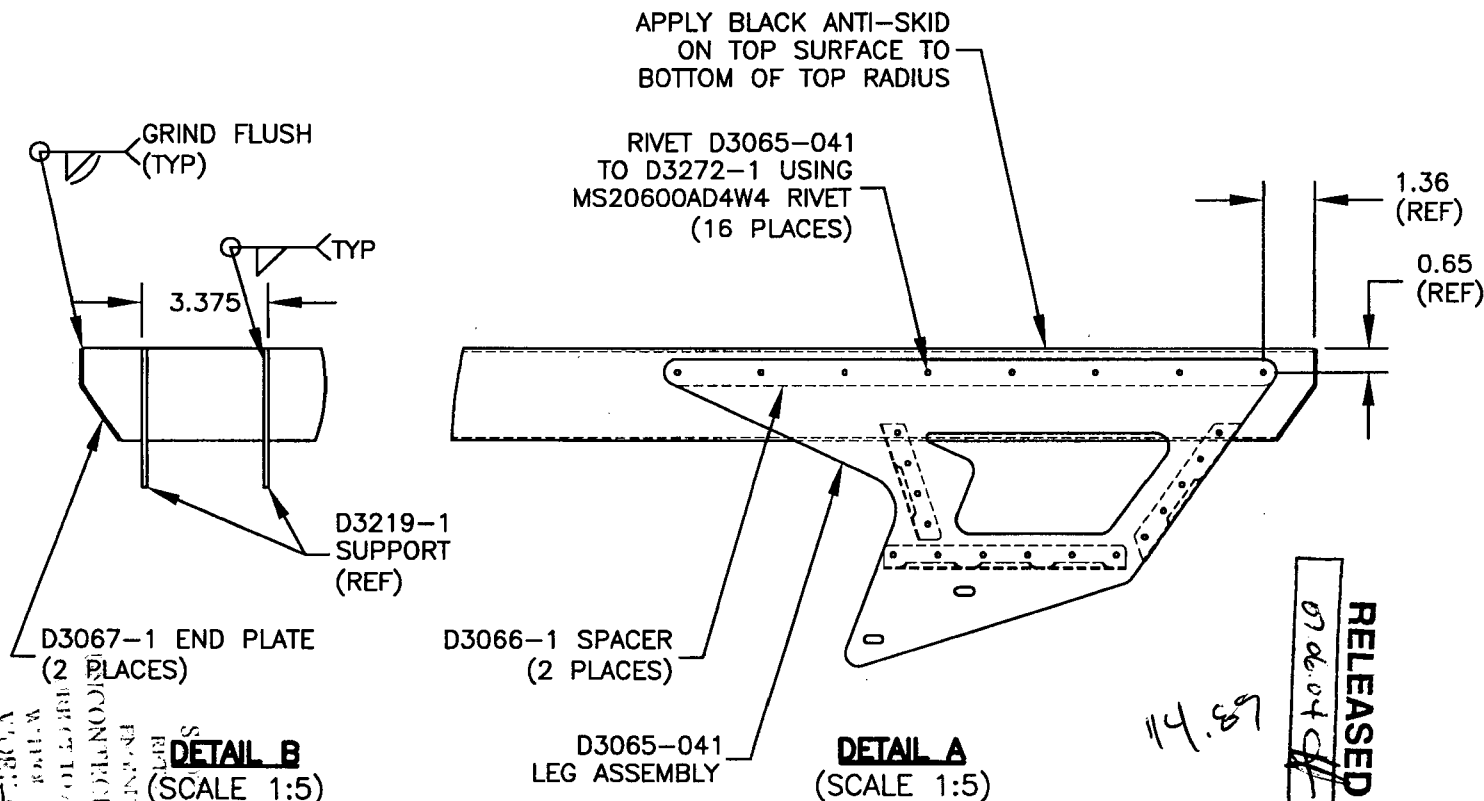
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D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DETAIL B
(SCALE 1:5)

NO. 45399

RECEIVED
DATE 07.06.04
BY [signature]

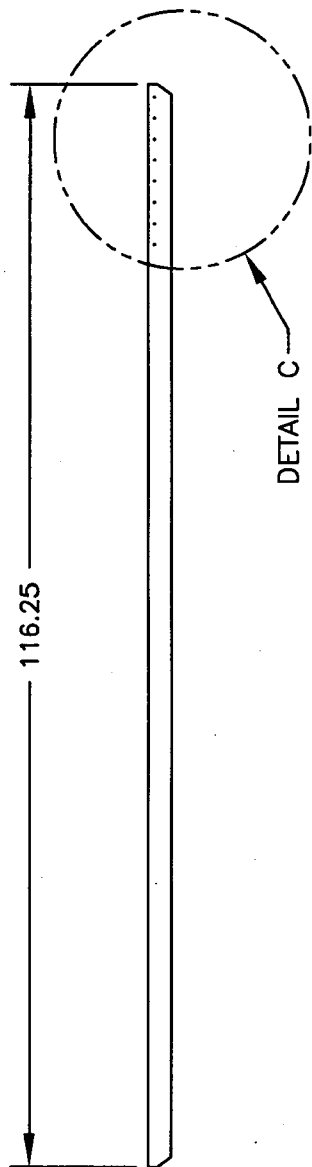
| DESIGN | DRAWN BY | DART AEROSPACE LTD | REV. B |
|---------------------|------------------------------|-----------------------------|--------------|
| CHECKED [signature] | APPROVED [signature] | HAWKESBURY, ONTARIO, CANADA | SHEET 2 OF 3 |
| DATE 07.05.18 | TITLE STEP ASSEMBLY, HI LONG | SCALE 1:20 | |



| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>GP</i> | DRAWN BY <i>JB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>LE</i> | APPROVED <i>JB</i> | DRAWING NO. D3272 | REV. B SHEET 3 OF 3 |
| DATE 07.05.18 | | TITLE STEP ASSEMBLY, HI LONG | SCALE 1:20 |

RELEASED

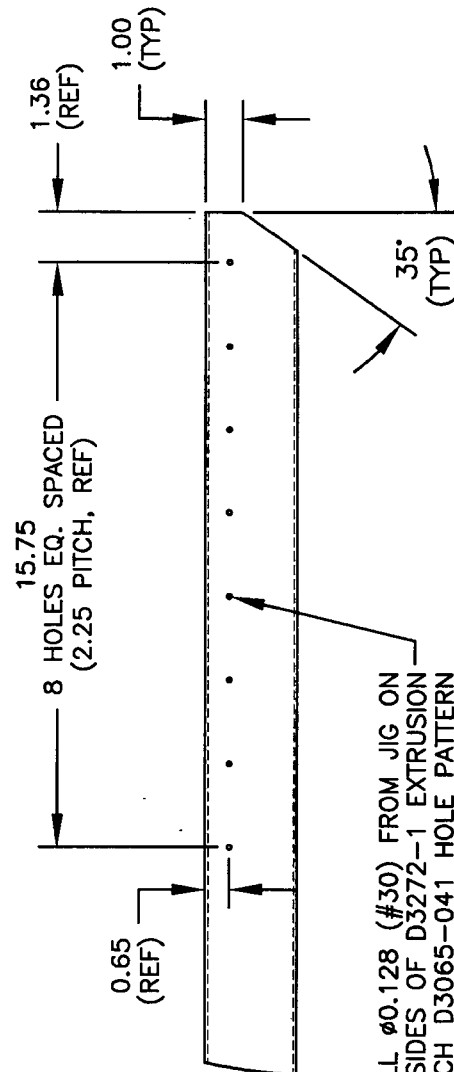
07.06.04 *JB*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DETAIL C
(SCALE 1:5)

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